

Work Order ID 119663

Friday, May 16, 2014 1:58:49 PM

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Item ID: D3537-1

Revision ID:

Item Name: Wearpad

Start Date: 5/15/14

Start Qty: 50.00

Required Date: 5/15/14

Req'd Qty: 50.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: 14-05-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

100

Waterjet

FLOW ENC Waterjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr
if necessary

60

0

Jm 14-05-24
mm

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

60

0

Jm 14-05-24
mm

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

JAS
27
14/5/27

60

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[illegible]

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Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 5/15/14 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 9 9-89
170 *170* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 125008</i> Memo START TIME: <i>2:20</i> OVEN TEMPERATURE: <i>325</i> FINISH TIME: <i>2:50</i>	0.00 0.00							<i>(60)</i> <i>14-05-30</i> <i>-4</i> <i>36</i> <i>14-6-2</i> DAS 34 9-89
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>56</i> <i>SPG</i> <i>14/6/3</i>

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Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 5/15/14

Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/15/14

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: FP-001

0.00

190

Packaging

Memo

0.00

Packaging

X56 of 44 relabeled

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

ML5 14-06-03

U4-0603

Picklist Print

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Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

300.7670

0.106

6

M304S16GA

**

Jm14-05-24.

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

300.767

M127821

75.567

M128423

1.2

M129192

224

129192

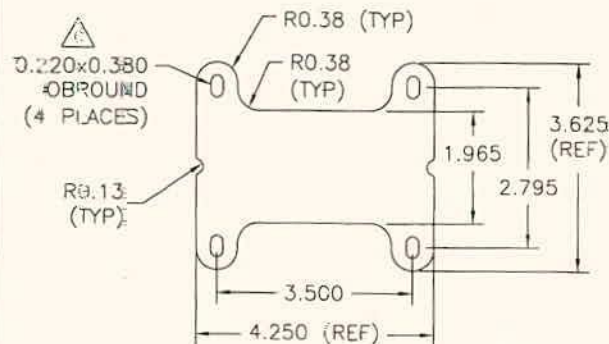
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

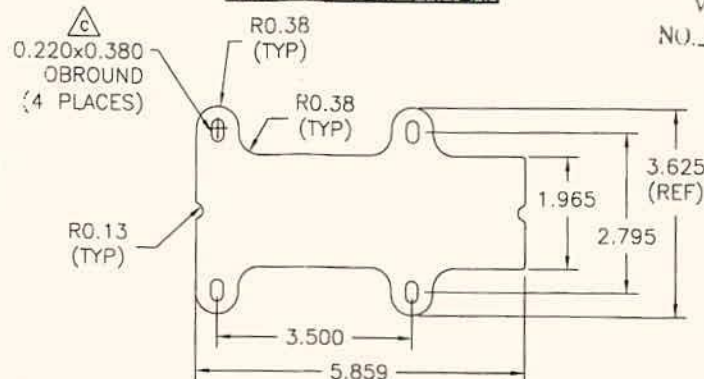
WORK ORDER

NO. 119663 MW
14-05-23

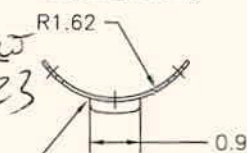
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

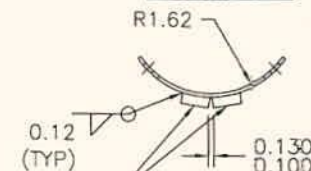


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B

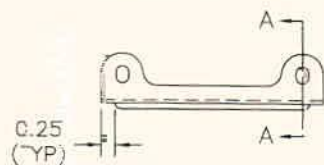


D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

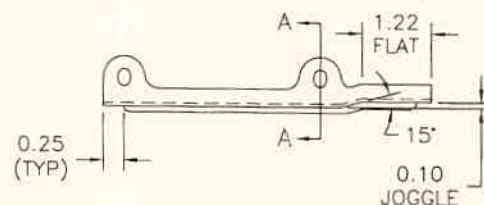
UNDER REVIEW
11/10/14
OK 9/11/15

RELEASED
07.05.08 RH
per ECU
962

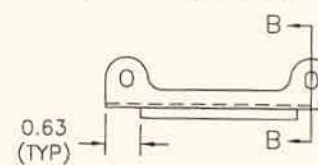
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



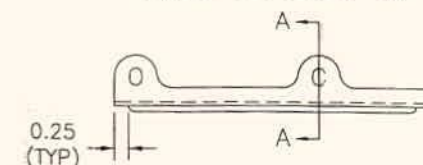
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1 SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA